

# Work Order ID 84478

**\*84478\***

Page 1

May-15-12 1:04:41 PM

Item ID: D206-642-412

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 5/14/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-642	O

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D206-642-412

CHG006

0.00

0.00

*5/16/12*

*JJ for MLS 12-6-11*

# Work Order ID 84478

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Item ID: D206-642-412 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH  
 Start Date: 5/14/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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101

\*101\*

HandFinish

Hand Finishing

## Memo

PULL FROM HK:  
 1 X D206-642-411 B39120  
 UPDATE TO CHG006 PER ECN08-538 & 09-531 DSI9421/9440

## REMOVE WEARPLATES:

6 X D2648-3 B34591  
 1 X D2656-15 B34596  
 1 X D2656-23 B34597  
 1 X D2656-37 B34510  
 1 X D3429-1 B34609  
 RETURN TO STK  
 DISCARD HARDWARE

## ADD:

6 X D3537-1 B \_\_\_\_\_  
 1 X D3537-3 B \_\_\_\_\_  
 1 X D3535-15 B \_\_\_\_\_  
 1 X D3536-15 B \_\_\_\_\_  
 1 X D3535-23 B \_\_\_\_\_  
 1 X D3536-23 B \_\_\_\_\_  
 1 X D3535-37 B \_\_\_\_\_  
 1 X D3536-37 B \_\_\_\_\_  
 60 X MS27039C1-08 B \_\_\_\_\_  
 60 X AN960C10L (NAS1149C0332R)  
 B \_\_\_\_\_

<b>DART</b>		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL #09-89			
P/N	D206-642-412	CHG	CHG004
DESC	Skidtube RH High	SIC	SH98-4
LOT	B39120	SIC	SA00475SE
MODEL	Bell 206L/L1/L3/L4	SIC	
US PATENT # 5735384 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

1 / 1 BR12-6-5.

# Work Order ID 84478

**\*84478\***

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Item ID: D206-642-412 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH  
 Start Date: 5/14/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105	QC5- Inspect part completeness to step on W/O	0.00							
<b>*105*</b>									
QC	Memo	0.00							
Quality Control									

*8/17/06/07*

# Work Order ID 84478

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Item ID: D206-642-412 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH  
 Start Date: 5/14/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Pick Kit	0.00							
*110*									
Packaging									
Packaging									
	Memo	0.00							
	REMOVE FROM KIT TO UPDATE TO CHG006:								
	1 X D2707-043(OR D2968-043)-SCRAP								
	1 X AN960JD1016 B	37380							
	1 X AN970-4 B	167715							
	1 X MS21041 B	107321							
	1 X AN4-5A B	106605							
	1 X AN960JD416 B	107321							
	1 X D2655 B	34613							
	RETURN TO STK								
	ADD TO KIT:								
	1 X D3407-043 B								
	1 X D3456-1 B	81826							
	2 X D3457-1 B	81977							
	1 X MS21043-4 B	121162							
	1 X AN4C5A B	119017							
	1 X AN960C416 B	119097							
	1 X D3413-1 B	83367							

12/6/12

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12/6/22

# Picklist Print

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Page 1

Work Order ID: 84478  
Parent Item: D206-642-412  
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.10.11Revised picklist per CHG004KJ/CP/JLM  
IPP Rev:L 07-12-05 ECN 1080p DD verified by:ec  
IPP Rev:M 08-09-29 as per DSI9421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5A Bolt		Purchased	No				Each	974.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		974							
				120562		974							
AN4C5A BOLT		Purchased	No				Each	199.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		199							
				112243		139							
				119017		60							
AN960C416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		1			
AN960JD1016 Washer	NAS1149C1063R	Purchased	No				Each	369.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		369							
				5519		369							
AN960JD416 Washer	NAS1149D0463I	Purchased	No				Each	30.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		30							
				116289		10							
				119097		20							

1066050

1

1

111909750

-1

1107321 12/6/75

# Picklist Print

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Page 2

Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Purchased No Each 203.0000  
Washer

-1 M 107713

Location	Loc Qty	Loc Code
ST344	203	
115936	11	
120308	3	
120644	30	
121285	159	

D206-642-412 Manufactured No Each 2.0000  
Skidtube RH

1 84478 SL

Location	Loc Qty	Loc Code
FG081	1	
78487	1	
FG082	1	
41319	1	

D2648-3 Manufactured No Each 9.0000  
Wearpad

-6 BL 126-5.

Location	Loc Qty	Loc Code
ST 34/591	-10	
81513	9	
ST237A	19	

6

D2655 Manufactured No Each 30.0000  
Ring

-1 B34613SD

Location	Loc Qty	Loc Code
ST464	30	
44295	15	
45738	15	

12/1/78

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Shop Packet Print

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# Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D2656-15 Manufactured No Each 6.0000  
Wearshoe

-1

BL 12-6-5.

Location	Loc Qty	Loc Code
FP 34596	5	
83601	5	
Mezz	1	
51455	1	

1

D2656-23 Manufactured No Each 9.0000  
Wearshoe

-1

BL 12-6-5.

Location	Loc Qty	Loc Code
Mezz 34597	9	
43407	2	
51468	7	

1

D2656-37 Manufactured No Each 21.0000  
Wearshoe

-1

BL 12-6-5.

Location	Loc Qty	Loc Code
Mezz	21	
34510✓	2	
44550	7	
46497	1	
53019	11	

1

S D3407-043 Manufactured No Each 14.0000  
Tow Ring

8<sup>13</sup> 325 jar sp

Location	Loc Qty	Loc Code
ST420	1	
79232	1	
ST463	13	
68339	2	
77504	10	
78841	1	

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3413-1 Ring Manufactured No Each 73.0000

1

Location	Loc Qty	Loc Code
ST420	4	
79233	4	
ST464	69	
76754	1	
80224	7	
83307	41	
83867	20	

D3429-1 Wearpad Manufactured No Each 16.0000

-1

Location	Loc Qty	Loc Code
FP002 34/609.	16	
40438	2	
43706	1	
44579	12	
65692	1	

D3456-1 Washer Manufactured No Each 168.0000

1

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	161	
80252	1	
81876	60	
83584	100	

# Picklist Print


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Work Order ID: 84478  
Parent Item: D206-642-412  
Parent Item Name: Skidtube RH

Start Date: 5/14/12  
Start Qty: 1.00

Required Date: 5/14/12  
Required Qty: 1.00

D3457-1 Washer	Manufactured	No	Each	35.0000	2	
D3535-15 Wearshoe	Manufactured	No	Each	17.0000	1	BR 12-6-5.
D3535-23 Wearshoe	Manufactured	No	Each	22.0000	1	BR 12-6-5.
D3535-37 Wearshoe	Manufactured	No	Each	4.0000	1	BR 12-6-5.
D3536-15 Gasket	Manufactured	No	Each	20.0000	1	BR 12-6-5.

# Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3536-23 Manufactured No Each 16.0000 1 BR 1265  
Gasket

Location	Loc Qty	Loc Code
FP002	16	
74510	1	
83377 ✓	15	

D3536-37 Manufactured No Each 19.0000 1 BR 1265  
Gasket

Location	Loc Qty	Loc Code
FP002	19	
66823	7	
82623 ✓	12	

D3537-1 Manufactured No Each 41.0000 6 BR 1265  
Wearpad

Location	Loc Qty	Loc Code
FG 84091	10	
79833	10	
FP002	31	
69817	5	
81362	22	
83254	1	
83255	3	

D3537-3 Manufactured No Each 28.0000 1 BR 1265  
Wearpad

Location	Loc Qty	Loc Code
FP002	28	
78836	5	
81363 ✓	23	

# Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21042-4  
USE MS21042L4

Purchased No

Each 1,071.0000

-1

1107478.5

Location	Loc Qty	Loc Code
ST299	1071	
100743	9	
119124	1000	
5461	1	
6844	19	
7690	24	
8182	6	
9063	8	
9229	4	

MS21043-4  
Nut

Purchased No

Each 1,546.0000

1

12/6/7.5

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1506	
119546	185	
121162	821	
121652	500	

MS27039C1-08  
SCREW

Purchased No

Each 1,142.0000

60

6126.5

Location	Loc Qty	Loc Code
FP002	1	
116022	1	
ST292	1122	
120308 ✓	354	
121068 ✓	108	
121162 ✓	660	
ST293	19	
116373	3	
118077	14	
119309	2	

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# Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each 3,354.0000

60

BR12-6-5.

Washer

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

3135

121255

11

121509✓

3124

60

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Shop Packet Print

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Dart Aerospace Ltd.

Date: Thursday, 08/05/2008 11:58:40 AM  
User: Julie Lecocq

### Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206L/L3/L4 HIGH GEAR SKID
<b>Job Number</b> : 39120	
<b>Estimate Number</b> : 10526	
<b>P.O. Number</b> :	<b>Part Number</b> : D206642412
<b>This Issue</b> : 08/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 1 / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : L
<b>Previous Run</b> : 39119	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 30/05/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JLD 08.5.08	
<b>Comment</b> : Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM Est Rev:L 07-12-05 ECN 1080p DD verified by:	

#### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL JLD 08.5.12  
Photocopy blueprints and create labels per PPP D206-642-412 CHG004 S 08/07/08

2.0	39120A	206 L HIGH GEAR SKIDTUBE
-----	--------	--------------------------



**Comment:** Sub-Component 206 L HIGH GEAR SKIDTUBE  
D206-642-441 B 39120A SQ

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
Pick Packing Kit

4.0	D20664811	GHW Modification
-----	-----------	------------------



**Comment:** Qty. 1 (10) Each(s)/Unit Total: 1.0000 Each(s)  
GHW Modification Kit  
Batch: 98/140

5.0	D2652	Bushing
-----	-------	---------



**Comment:** Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
Pick Packing Kit  
Qty Part Number Description Batch  
16 D2652 Bushing 38815  
1 D206-642-441(REF)

8/5/06

SQ

Date: Thursday, 08/05/2008 11:58:41 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39120

Part Number: D206642412

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

D2655

Ring



Comment: Qty. 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Pickling Q:

Qty Part Number

Description Batch

1 D2655

Tow Ring

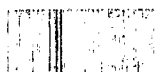
34163

scf

7.0

D2712

Set Screw



Comment: Qty. 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Pickling Q:

Qty Part Number

Description Batch

10 D2712

Set Screw

34602-8

scf

8.0

D25912

Saddle RH Out, 206



Comment: Qty. 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Pickling Q:

Qty Part Number

Description Batch

1 D25912

Saddle

37265 (=1)

39772

scf

9.0

D2412

Saddle RH In, 206



Comment: Qty. 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Pickling Q:

Qty Part Number

Description Batch

1 D2412

Saddle

37455 (=1)

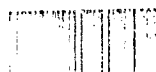
39885

scf

10.0

D2412

Saddle Spacer



Comment: Qty. 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Pickling Q:

Qty Part Number

Description Batch

2 D2412

Saddle Spacer

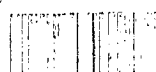
37328

scf

11.0

D2412

Saddle Spacer



Comment: Qty. 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Pickling Q:

Qty Part Number

Description Batch

2 D2412

Saddle Spacer

37867

8/5/06

scf

Date: Thursday, 08/05/2008 11:38:41 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39120

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29382

Saddle RH Out, 206



\* 39120 8/6/26



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Saddle Kit

Qty Part Number

1 D29382

Description: Saddle

Batch

~~39120~~

8/6/26

SP

13.0

D29392

Saddle RH In, 206



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Saddle Kit

Qty Part Number

1 D29392

Description: Saddle

Batch

~~39120~~

8/6/26

SP

14.0

D29394

Tow Ring



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Saddle Kit

Qty Part Number

1 D29394

Description: Tow Ring

Batch

~~39120~~

8/6/26

SP

15.0

AN341A

Bolt



Comment: Qty: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Picking Kit

Qty Part Number

8 AN341A

Description: Bolt

Batch

101242

8/6/26

SP

16.0

AN45A

Bolt



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Picking Kit

Qty Part Number

1 AN45A

Description: Bolt

Batch

106605

8/5/26

SP



Date: Thursday, 08/05/2008 11:58:41 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39120

Part Number: D206642412

Job Number:



Seq. #:

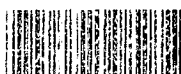
Machine Or Operation:

Description :

12

AN46A

Bolt



Comment: Qty: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick Packing Kit

Qty Part Number

12 AN46A

Description Batch

Bolt 106662

sq

18

AN513

Bolt



Comment: Qty: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch 104934

sq

10

AN512

Bolt



Comment: Qty: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick Packing Kit

Qty Part Number

4 AN512

Description Batch

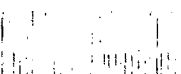
Bolt 104885

sq

20

AN511

Bolt



Comment: Qty: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch 105810

sq

21

AN960

Washer



Comment: Qty: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick Packing Kit

Qty Part Number

8 AN960-010

Description Batch

Washer 9231

(x)

8/5/26

sq

Date: Thursday, 08/05/2008 11:58:41 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39120

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description:

28.

QC4

INSPECT 10 Kits FOR COMPLETENESS



Comment: INSPECT 10 Kits FOR COMPLETENESS

*Soderfors*

29.0

PACKAGING

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Ident. and label for shipping as per PPP D206-642-412

Location:

PPP Title:

30.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

*08/07/08*

Job Completion:



*mf 08-07-04*

**39120A**

Date: Thursday, 08/05/2008 11:59:05 AM  
User: Julie Leococq

## Process Sheet

Customer : CU-DART01 Dart Helicopters Services  
Job Number : 39120A  
Estimate Number : 10522  
P.O. Number :  
This Issue : 08/05/2008 S.C. No. :  
Prsht Rev. : NC  
First Issue : 11 Type : SKIDTUBES  
Previous Run : 39119A  
Drawing Name : 206 L HIGH GEAR SKIDTUBE  
Part Number : D206642441  
Drawing Number : D2650 REV E  
Project Number : N/A  
Drawing Revision : E  
Material :  
Due Date : 30/05/2008 Qty: 1 Um: Each  
Written By :  
Checked & Approved By : JD 08.508  
Comment : Est Rev: h 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM  
Est Rev: 08-05-01 add Q03 DO verified by EC

## Additional Product:

Job Number:



Seq. #:

Machine Operation:

Description:

10

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

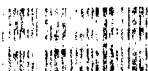
Photo of job and control labels per PPF D206-642-441 CHG002

N/A JD

20

D2649

skidube, 206 Skidtube



Comment: Qty: 1.000 Each(s)

Proc:

Dk: 20649

Description:

Batch:

1.000

20649 3" OD

32449BE 08-05-12

Comment: Qty:

Proc:

Dk:

1.000

Description:

Batch:

1.000

20649 3" OD

32449BE 08/05/12

Comment: Qty:

Proc:

Dk:

1.000

Description:

Batch:

1.000

20649 3" OD

32449

Comment: Qty:

Proc:

Dk:

1.000

Description:

Batch:

1.000

20649 3" OD

32449

Comment: Qty:

Proc:

Dk:

1.000

Description:

Batch:

1.000

20649 3" OD

32449

Comment: Qty:

Proc:

Dk:

1.000

Description:

Batch:

1.000

20649 3" OD

32449

Date: Thursday, 08/05/2004 11:59:05 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39120A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end 138.60" from front of tube

6-Drill 1/4" dia. hole in DTG 125 & DTS 110 (A,B,C,D). Open to Ø0.312".

7-Drill 1/4" dia. hole in plates using E T 8028-7. Open to Ø0.297".

8-Drill 1/4" dia. hole in DTG 125 & DTS 110 (A,B,C,D).

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650 D2650-7 Drilling Detail

10-Flare the inner ring on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

SL 8-5-13

5.0

9/1/2004

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

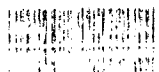
Character: 1/4" dia. hole as per DTS 005 4.1

SL 8-5-13

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



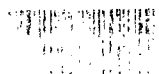
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① W 8-5-13

7.0

D2654

Web



Comment: Qty. 1000 (Unit Total 1,000) Each

Prior

Qty. 1000

Description

Batch

Web

34594

SL 8-5-13

8.0

SKIDTUBE

SKIDTUBE RESOURCE 1



Comment: SKIDTUBE RESOURCE 1

1-Drill 1/4" dia. hole in DTG 125 & DTS 110 (A,B,C,D) (without cutting fluid)

2-Drill 1/4" dia. hole in plates using E T 8028-7 (without cutting fluid)

3-Drill 1/4" dia. hole in plates. Grind all line off around crossbolt spacer.

4-Bond D2654-1 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 8-5-13 Time: 12:35

Finish Date: 8-5-14 Time: 12:00

SL 8-5-13

Date: Thursday, 08/05/2003 11:59:05 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39120A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R Sikaflex 291

107604

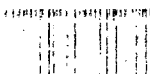
Sikaflex expiry date:

8-7-01

9.

QCC

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/04

10.

D2649

Cross Bolt Spacer



Comment: Qty: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick

Qty: 23.0000

Description:

Batch

10 D2649

Cross Bolt Spacer

087659

08/05/04

11.

SKIDTUBE

SKIDTUBE RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Inch ... Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole  
to ... Use aluminum rod.

2-Inch ...

08/05/04

08/05/04

2-Inch ... Masking Tape access to inside of the Skidtube

08/05/04

3-Inch ... 0.750" deep as per Dwg D2650

08/05/04

12.

D2650

Nut Plate



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick

Qty: 1.0000

Description:

Batch

12 D2650

Nut Plate

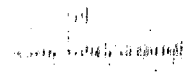
087659

08/05/04

13.

CCR254

Cherry Rivet



Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick

Qty: 2.0000

Description:

Batch

13 CCR254

Rivets

087659

08/05/04

Date: Thursday, 08/05/2003 11:09:05 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39120A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

M7085343

Rivet



Comment: Qty: 2.000 Each(s) Total: 2.0000 Each(s)

Pick

X

Qty. Number

Description Batch

3 1073-47

Rivets 1073-5

SL 8-5-20

16.0

HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Instal 22-504 1.0 Pa. 1.00 per Dwg D2650

SL 8-5-20

16.0

QC

VISUAL INSPECTION OF GROUND WELDS

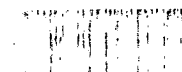


Comment: VISUAL INSPECTION OF GROUND WELDS

17.0

QC5

INSPECT WORK TO CURRENT STEP

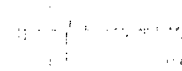


Comment: INSPECT WORK TO CURRENT STEP

18.0

HAND FINISHING

HAND FINISHING RESOURCE #1



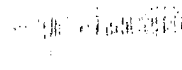
Comment: HAND FINISHING RESOURCE #1

Powder Coating

19.0

Powder Coating

POWDER COATING



Comment: Powder Coating

Pow. 7000 White R.F. 4.0.5.1) as per QS: 005 4.3

Make sure that all thread protected use paint screw

3-50 am

3-20 of

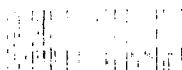
3-20 of

3-20 am

20.0

QC

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SL 08-05-21

Date: Thursday, 08/05/2022 11:59:05 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Part Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 391204

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation

Description :

21

D20664

Wearpad



Comment: Qty: 10000 Each(s) Total: 6.0000 Each(s)

Pick:

Qty: 10000

Description: Batch

Wearpad

Wearpad

15344571

BR.

22

D20664

Wearshoe



Comment: Qty: 10000 Each(s) Total: 1.0000 Each(s)

Pick:

Qty: 10000

Description: Batch

Wearshoe

Wearshoe

1534576

BR.

23

D25562

Wearshoe



Comment: Qty: 10000 Each(s) Total: 1.0000 Each(s)

Pick:

Qty: 10000

Description: Batch

Wearshoe

Wearshoe

1534577

BR.

24

D25562

Wearshoe



Comment: Qty: 10000 Each(s) Total: 1.0000 Each(s)

Pick:

Qty: 10000

Description: Batch

Wearshoe

Wearshoe

1534578

BR.

25

D34291

Wearpad



Comment: Qty: 10000 Each(s) Total: 1.0000 Each(s)

Pick:

Qty: 10000

Description: Batch

Wearpad

Wearpad

1534579

BR.

26

A106500-1

Insert



Comment: Qty: 60000 Each(s) Total: 60.0000 Each(s)

Pick:

Qty: 60000

Description: Batch

Insert

Insert

1534580

BR.

BR 08-05-22

Date: Thursday, 08/05/2008 11:59:05 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DA3001 For Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39120A

Part Number: D206642441

Job Number:



Seq. #:

Machining Or Operation:

Description :

32...

MS27030-03

Screw



Comment: Qty. 1.0000 Each(s) Total: 1.0000 Each(s)

Pick

Qty Per Number

Description Batch

1 MS27030-03

Screw

BR. 08/05/22

33

MS27030-03

Cap



Comment: Qty. 1.0000 Each(s) Total: 1.0000 Each(s)

Pick

Qty Per Number

Description Batch

1 MS27030-03

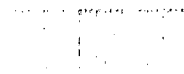
Cap

BR. 08/05/22

34

MS27030-03

AND FINISHING RESOURCE #1



Comment: AND FINISHING RESOURCE #1

1-Install the weapon as per dwg D2652. Use a drop of Sikaflex inside insert holes before installing weapon.

2-Install the weapon as per dwg D2652.

Sikaflex inside insert holes.

3-Apply the D-2653 or plug D2650 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

4-Install MS27030-4-06 Screw as per D2653

5-Install the foreign object per QS. 024

6-Install the D-2653 and seal with Sikaflex. Clean excess adhesive

7-Install the D-2653

Sikaflex inside insert holes

8-Verify the work as per Dwg D2650-7 and QS. 024

9-Verify the work as per Dwg D2650-7 and QS. 024

35.0

Q05

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/22



Part Number D206-642-412  
Description 206 SKIDTUBE INSULATION

[illegible]

**ENGINEERING CHANGE NOTICE**  
**DART AEROSPACE LTD**

Date: 09.02.18	Job No.: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: <i>[Signature]</i>		
Product Name: Skidbe Installation	Checked By: <i>[Signature]</i>	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date	Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>LL 09.02.19</i>	DQA / QA Coord			
Production Engineering Coord	Y	EC/DD	<i>EC/DD 09.02.19</i>	QC Coordinator	Y	JM	<i>JM 09.02.19</i>
Production Document Control	Y	JLD	<i>JLD 09.02.19</i>	Marketing	Y	SW	<i>SW 09.03.11</i>
Customer Technical Support				Customer Order Processing			

**Reason for Change:** DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

**Documents Affected:**  
 DSI 9421 REV B  
 DSI 9440 REV A  
 D206-648 REV B  
 D3414 Rev B

**PARTS MUST COMPLY** ☐ **PREVIOUS PARTS SATISFACTORY** ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		<i>09.02.19</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		<i>09.02.19</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		<i>09.02.19</i>
10	Update Controlled PDF Files	Y	KJ		<i>09.02.19</i>
11	Update Master Document List (MDL)	Y	AJS	<i>Rev. U</i>	<i>09.02.19</i>
12	Update Document Record (DR)	Y	KJ		<i>09.02.19</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	<i>SEE BELOW</i>	<i>09.02.19</i>
18	Create / Update PPP's	Y	KJ		<i>09.02.19</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		<i>09.02.19</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>09.02.19</i>
22					
23					

**Description / Action:**  
 Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)  
*-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)*  
 Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)  
*-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)*  
 Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005  
  
 Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006  
**D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) - DO NOT MIX PARTS**

ECN Verified & Complete: *[Signature]*

Date: *09/03/16*

# **ENGINEERING CHANGE NOTICE** **DART AEROSPACE LTD**

Date: 09.02.18	Job No: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: [Signature]		
Product Name: Skidbe Installation	Checked By: [Signature]	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date	Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL		DQA / QA Coord			
Production Engineering Coord	Y	EC/DD	11/02/19	QC Coordinator	Y	JM	09.02.19
Production Document Control	Y	JLD	09.02.19	Marketing	Y	SW	
Customer Technical Support				Customer Order Processing			

**Reason for Change:** DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

**Documents Affected:**  
DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

**PARTS MUST COMPLY** ☐ **PREVIOUS PARTS SATISFACTORY** ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.02.19
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19
10	Update Controlled PDF Files	Y	KJ		09.02.19
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19
12	Update Document Record (DR)	Y	KJ		09.02.19
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19
18	Create / Update PPP's	Y	KJ		09.02.19
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19
22					
23					

**Description / Action:**  
Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)  
-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)  
Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)  
-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)  
Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005  
  
Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006  
**D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS**  
  
N/A  
JLD 09.03.03

ECN Verified & Complete: \_\_\_\_\_ Date: \_\_\_\_\_

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	08.10.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)  
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>NA</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>NA</del>	TITLE	SCALE
DE APPR.	<del>NA</del>	WEARSHOE CHANGE	NTS
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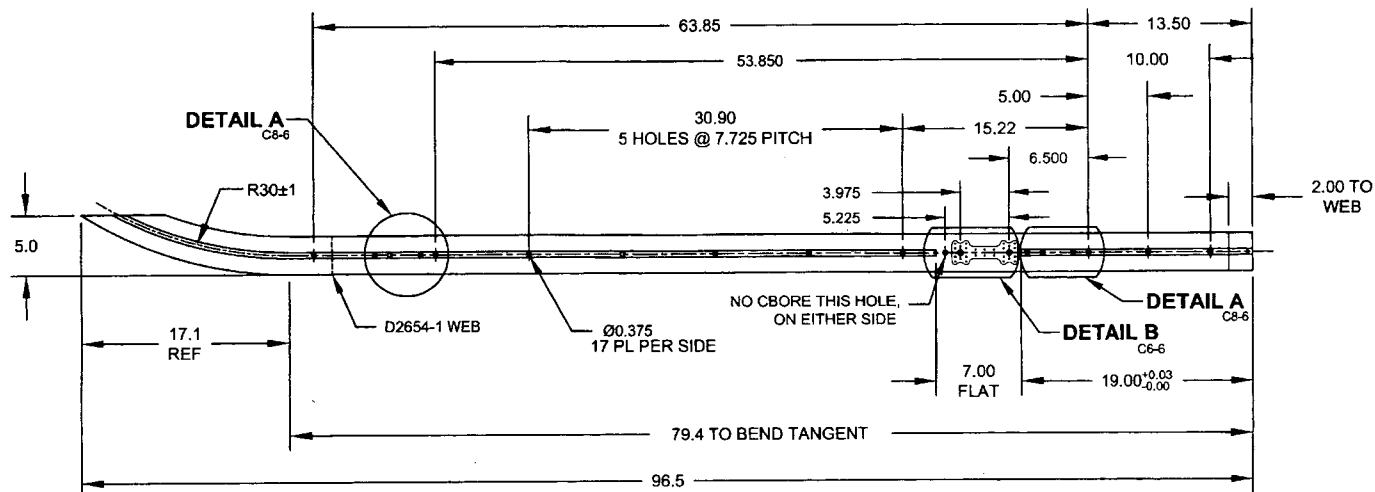
QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

**NOTES:**

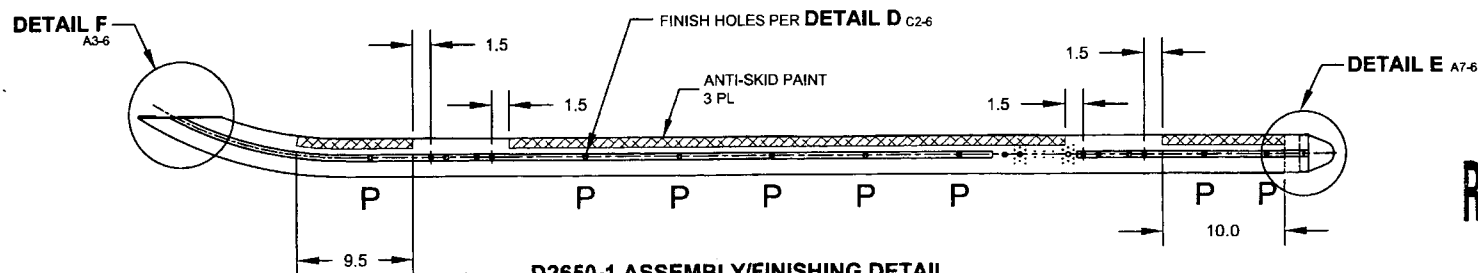
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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08-23-17



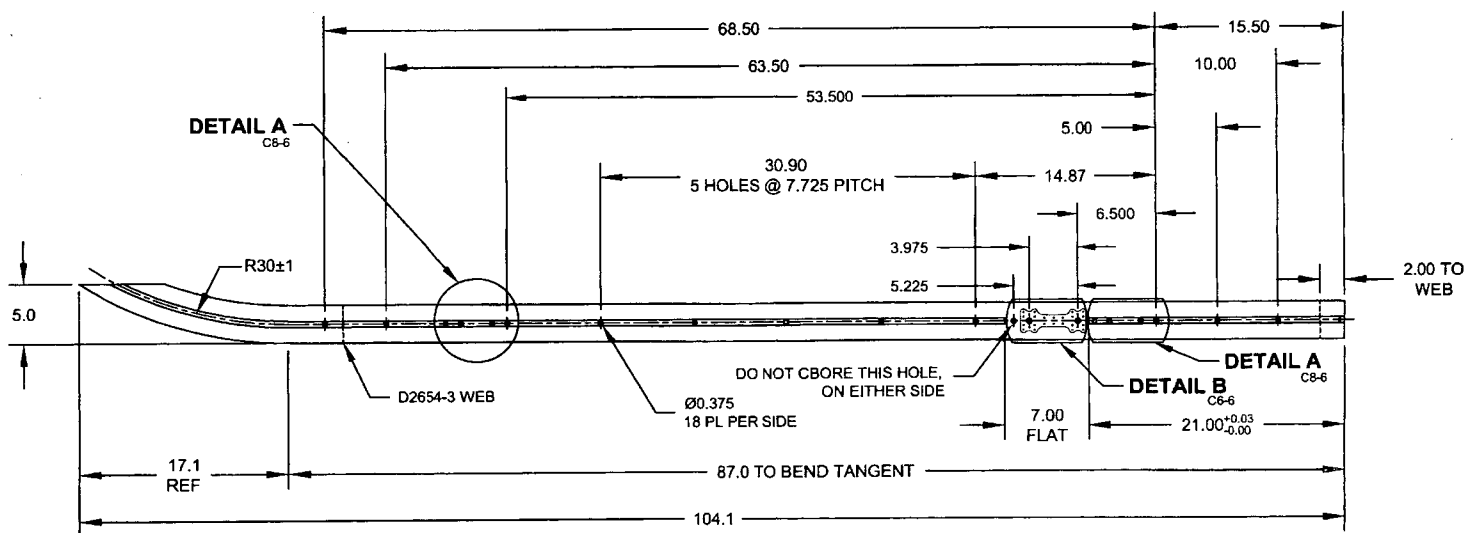
**D2650-1 BENDING/DRILLING DETAIL**



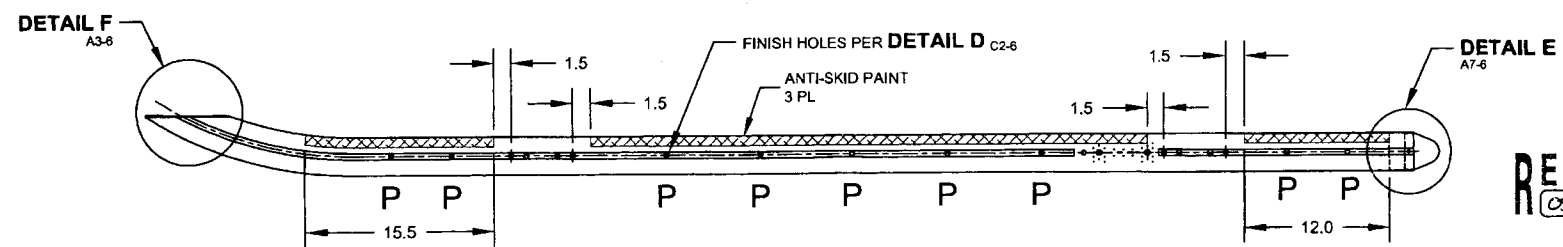
**D2650-1 ASSEMBLY/FINISHING DETAIL**

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**D2650-3 BENDING/DRILLING DETAIL**



**D2650-3 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
05 07 22 1997

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DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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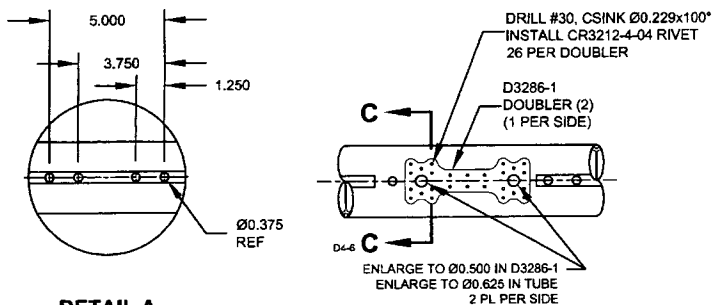




RELEASE  
OCT 09 22 1977

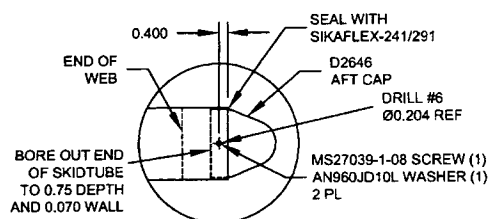
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CHECKED		DRAWING NO.	REV. F
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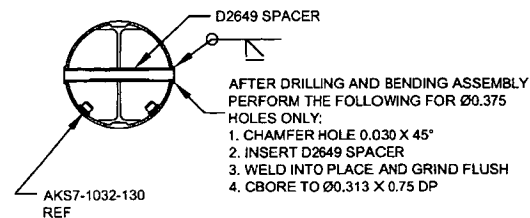
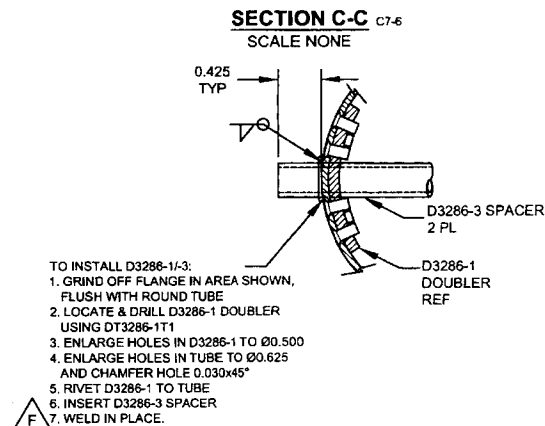


**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

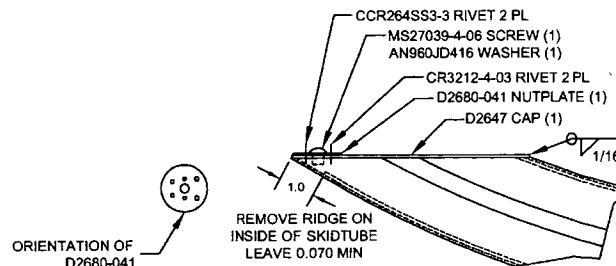
**DETAIL B**  
SCALE 2X  
C3-2  
C3-3



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
08-08-2008

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